

Work Order ID 71468

Monday, July 04, 2011 10:48:19 AM



Page 1

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Crosstube Turning DetailL

Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 11-07-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-667-143	Rev C U/R OK 11.07.04

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Blend transition lines only, **do not sand whole tube**

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

MM.L 11/07/13

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

MM.L 11/07/13

MM.L 11/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Mori Seiki Mori Seiki CNC Lathe Large	MORI SEIKI CNC LATHE LARGE Memo 1-Turn second side as per Folio FA087 2-File down transition lines smooth. 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.	0.00 - 0.00				1	0		
130 QC Quality Control	QC1- Inspect dimensions to dimension sheet Memo	0.00 0.00				1	0		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				1			

MM-L 11/07/13

ML 11/07/13

Q 11.07.14

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Required Date: 7/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

SAD 11-07-15

①

Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

DP

11-7-15

Quality Control

170

Packaging

0.00



Packaging

Memo

0.00

Identify and stock in kanban rack ☐ Location:

46

DP

11-7-15

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/7/14

MF
11-07-14

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Picklist Print

Monday, July 04, 2011 10:48:17 AM

Page 1

Work Order ID: 71468



Parent Item: D206-667-103TRN



Parent Item Name: Crosstube Turning DetailL


Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed polish EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6002-115 		Manufactured	No			110	Each	23.0000	1	1			

Crosstube Material

Location

Loc Qty

Loc Code

LG

23

34684

1

34776

22

1

man 11/20/12

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	71468
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	✓		mic	CNC-04
	1.982	+0.005/-0.000	1.987	✓		vern	JF-01
	2.019	+0.005/-0.000	2.024	✓		mic	CNC-04
	2.058	+0.005/-0.000	2.063	✓		II	
	2.097	+0.005/-0.000	2.102	✓		II	
	2.136	+0.005/-0.000	2.141	✓		II	
	2.176	+0.005/-0.000	2.180	✓		II	
	2.201	+0.005/-0.000	2.205	✓		VI	
	0.125	+/-0.010	0.125	✓		vern	JF-01
	0.400 x 30°	+/-0.010	0.400 x 30°	✓		II	
	R0.063	+/-0.010	0.063	✓		RG	
	R0.500	+/-0.010	0.500	✓		II	
	4.438	+/-0.030	4.415	✓		vern	JF-01
SIDE B	104.98	+/-0.020	104.95	✓		tape	mm.l-02
	2.240	+0.005/-0.000	2.245	✓		mic	CNC-04
	1.982	+0.005/-0.000	1.987	✓		vern	JF-01
	2.019	+0.005/-0.000	2.024	✓		mic	CNC-04
	2.058	+0.005/-0.000	2.063	✓		II	
	2.097	+0.005/-0.000	2.102	✓		II	
	2.136	+0.005/-0.000	2.141	✓		II	
	2.176	+0.005/-0.000	2.181	✓		II	
	2.201	+0.005/-0.000	2.205	✓		VI	
	0.125	+/-0.010	0.125	✓		vern	JF-01
	0.400 x 30°	+/-0.010	0.400 x 30°	✓		II	
	R0.063	+/-0.010	0.063	✓		RG	
	R0.500	+/-0.010	0.500	✓		RG	
	4.438	+/-0.030	4.415	✓		vern	JF-01

Measured by:	JMM	Audited by:	R	Preliminary Approval:	N/A
Date:	11/07/12	Date:	11.07.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	10.09.13	Dwg Rev updated	KJ	

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Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNDER REVIEW

08.11.06.13

RELEASED
08/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D8-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NOR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-143	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (206L HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

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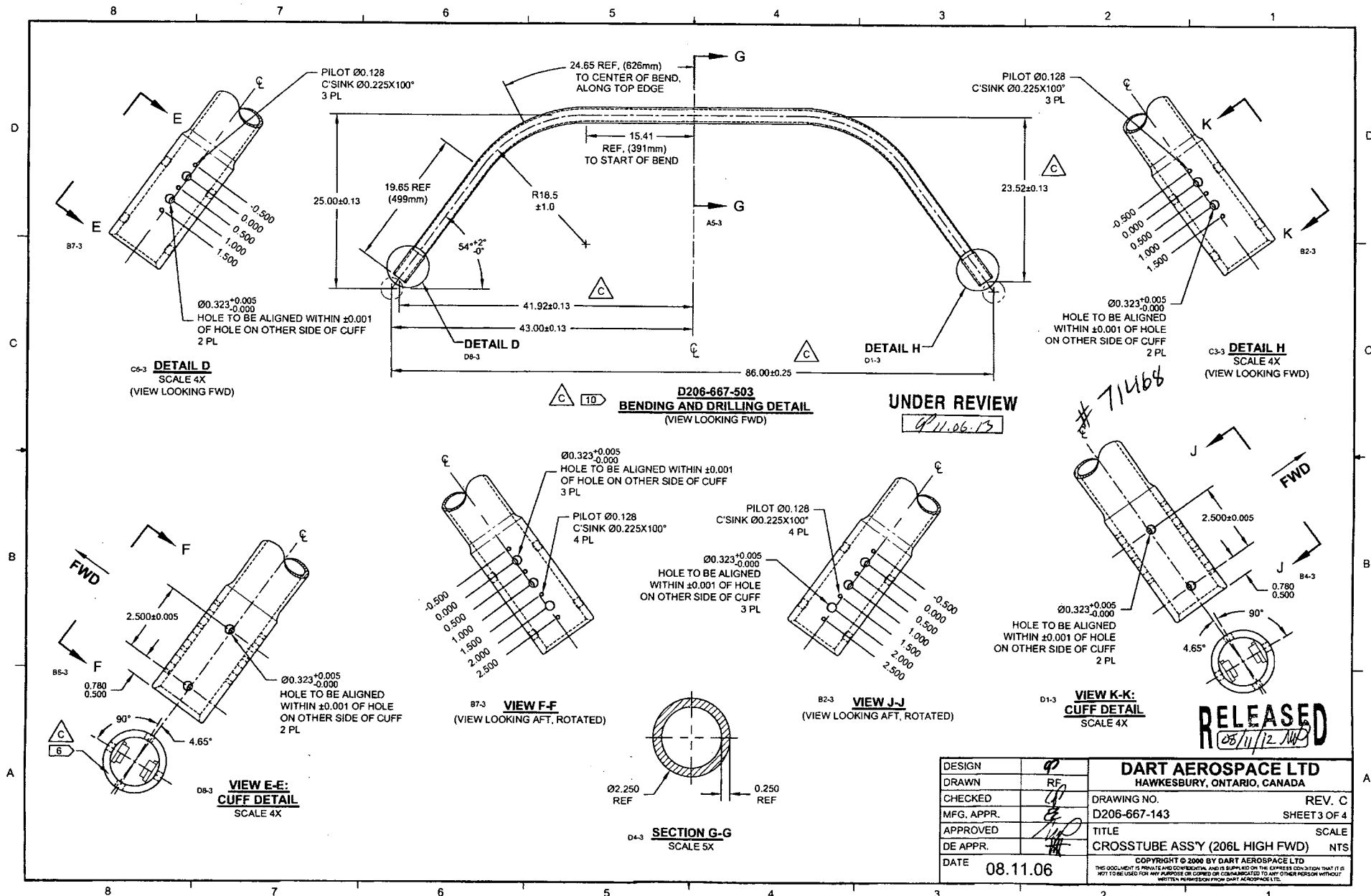
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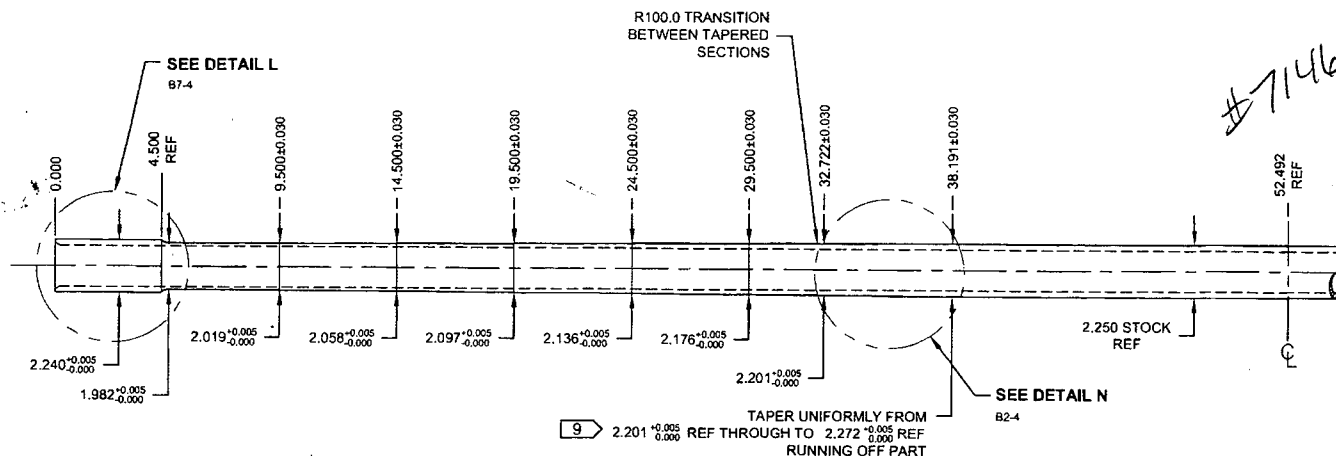
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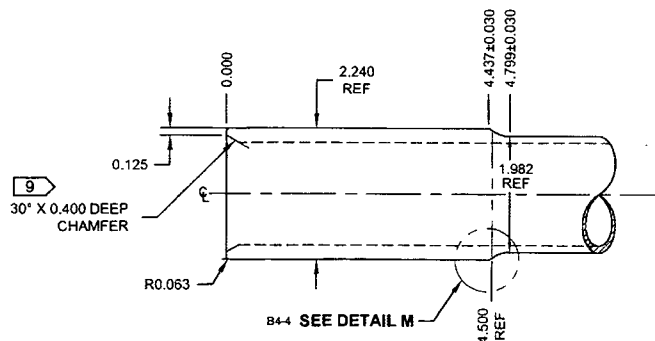
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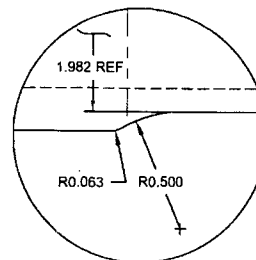
UNDER REVIEW

11.06.13

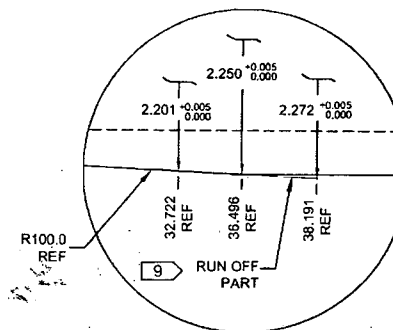
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
NOT TO SCALE

RELEASED
08/11/12

DESIGN	4	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. C
MFG. APPR.	4	D206-667-143	SHEET 4 OF 4
APPROVED	4	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASSY (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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